

1 **1. (canceled)**

1 **2. (canceled)**

1 **3. (canceled)**

1 **4. (canceled)**

1 **5. (canceled)**

1 **6. (canceled)**

1 **7. (canceled)**

1 **8. (canceled)**

1 **9. (canceled)**

1 **10. (canceled)**

1 **11. (canceled)**

1 **12. (canceled)**

1 **13. (canceled)**

1 **14. (canceled)**

1 **15. (canceled)**

1 **16. (canceled)**

1 **17. (previously presented)** A method of making lugs for joints in a bicycle frame made
 2 of carbon fiber tubes,
 3 the method comprising the steps of:
 4 making a lay-up of at least carbon fibers and a matrix material around the joint,
 5 applying a mold to the tubes and laid-up fibers and matrix material, and
 6 curing the lug in the mold, the cure including expansion of an element located
 7 between the mold and the tubes.

1 **18. (currently amended)** The method set forth in claim 17 wherein:
 2 the mold is a captured silicon mold; and
 3 in the step of curing the lug in the mold, the element is the captured silicon.

1 **19. (previously presented)** The method set forth in claim 17 wherein:
 2 the step of making the lay-up includes the step of including a layer of expanding
 3 foam in the lay-up; and
 4 in the step of curing the lug in the mold, the element is the expanding foam.

1 **20. (original)** The method set forth in claim 17 wherein:
 2 the step of making a lay-up includes the steps of:
 3 wrapping each tube in the joint with a first carbon fiber fabric that is impregnated
 4 with the matrix material, the ends of the fabric extending beyond the tube;
 5 wrapping the ends of the carbon fiber fabric that is wrapped around a given tube
 6 around the tube the given tube joins to;
 7 wrapping the entire joint in a second carbon fiber fabric whose fibers have an
 8 orientation different from that of the fibers in the first carbon fiber fabric.

1 **21. (original)** The method set forth in claim 20 wherein:
 2 the step of making a lay-up further includes the step of:
 3 including a layer of expanding foam in the lay-up.

1 **22. (original)** The method set forth in claim 21 wherein:

2 the step of including a layer of expanding foam is performed before the step of
3 wrapping the entire joint in a second carbon fiber fabric.

1 **23. (original)** The method set forth in claim 20 wherein:

2 the step of wrapping the entire joint is done such that all seams in the second
3 carbon fiber fabric are at the top and bottom of the tubes and the second carbon fiber
4 fabric is overlapped at the seams.